

# Work Order ID 100944

May-01-13 7:09:33 AM

\*100944\*

Page 1

Item ID: D3639-4

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Doubler

Start Date: 4/30/13 Start Qty: 6.00

Cust Item ID:

Required Date: 4/30/13 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: MLC

Date: 13-05-03 Tooling:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D3639

Rev A

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3639

2024-05-01

Dwg Rev: A

Prog Rev: A

2-Debur if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other  _____ _____ _____
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# Work Order ID 100944

May-01-13 7:09:33 AM

\*100944\*

Page 2

Item ID: D3639-4

Revision ID:

Item Name: Doubler

Start Date: 4/30/13

Required Date: 4/30/13

Reference:

Start Qty: 6.00

Req'd Qty: 6.00

\*6\*

\*6\*

\*N900040100\*

Cust Item ID:

Customer:

Setup Start \*NS1\*

Stop \*NS2\*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

Stop \*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

\*130\*

Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D3639

0.00

0.00

WAS

27

8-09

140

\*140\*

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

13801

150

\*150\*

HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

Memo

0.00

0.00

WAS  
27  
2-8

QC 3

—————>

13801

Receiving

—————>

~~10 13801~~  
2 13801  
2

2x

SP 13-8-27

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td style="width: 33%;">           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </td> <td style="width: 33%;">           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </td> <td style="width: 33%;">           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </td> <td style="width: 33%;">           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Equip/Tooling									
Handling/Pre									
Material									
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Offset/Setup									
Process									
Supplier									
Training									
Transport									
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# Picklist Print

May-01-13 7:09:33 AM

Page 1

Work Order ID: 100944

Parent Item: D3639-4

Parent Item Name: Doubler

Start Date: 4/30/13

Required Date: 4/30/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050 2024-T3 .050 sheet		Purchased	No			100	sf	202.1920	0.4277	2.701263			

13.08.01

Location

MAT022

Loc Qty

202.192

Loc Code

202.192

1.24643

S.1368607  
Residual's not → 124643 ..



AIRCSPACE LTD		Work Order:	
Section: Doubler		Part Number:	D3635-4
Section Dwg: D3639	Rev: A	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
20.625	+0.008/-0.001	6.24	-		v	
20.19	+0.005/-0.001	1.90	-		v	
20.098	+0.004/-0.001	1.07	-		v	
0.45	+/-0.030	.45	-		v	
1.367	+/-0.010	1.351	-		v	
2.25	+/-0.030	2.25	-		v	
3.15	+/-0.030	3.15	-		v	
4.05	+/-0.030	4.05	-		v	
4.95	+/-0.030	4.95	-		v	
5.85	+/-0.030	5.85	-		v	
6.75	+/-0.030	6.75	-		v	
7.65	+/-0.030	7.65	-		v	
8.55	+/-0.030	8.55	-		v	
9.350	+/-0.010	9.350	-		v	NK01-04
9.45	+/-0.030	9.45	-		v	
10.350	+/-0.010	10.350	-		v	
11.25	+/-0.030	11.25	-		v	
12.15	+/-0.030	12.15	-		v	
12.85	+/-0.030	12.85	-		v	
13.55	+/-0.030	13.55	-		v	
13.95	+/-0.030	13.95	-		v	
0.805	+/-0.010	.805	-		v	
1.00	+/-0.030	1.00	-		v	
2.100	+/-0.010	2.100	-		v	
3.30	+/-0.030	3.30	-		v	
2.090	+/-0.010	2.090	-		v	
2.590	+/-0.010	2.590	-		v	

Inspected by: A  
Date: 18-08-07

Audited by: [Signature]  
Date: 18-8-07

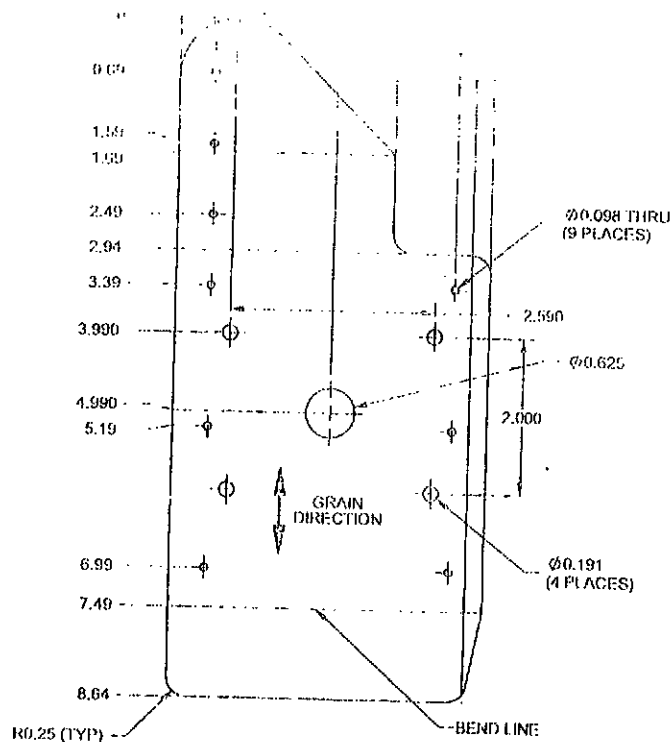
Prototype Approval: N/A  
Date: N/A

Date: Change  
27.10.24 - New Issue

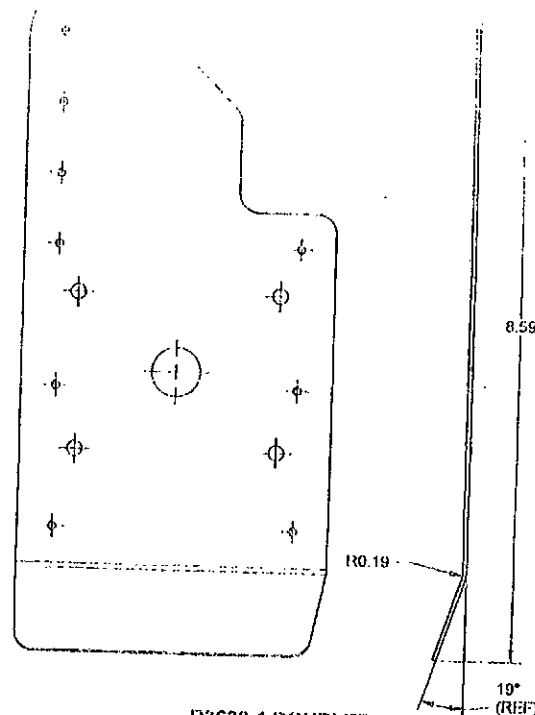
Revised by: [Signature] Approved  
KJ/EC/DD







**D3639-1F FLAT PATTERN**  
**(D3639-2F OPPOSITE)**



**D3639-1 DOUBLER**  
**(WAS GENEVA P/N G10604-3)**  
**D3639-2 OPPOSITE**  
**(WAS GENEVA P/N G10604-6)**

**RELEASED**  
(07-07-27)

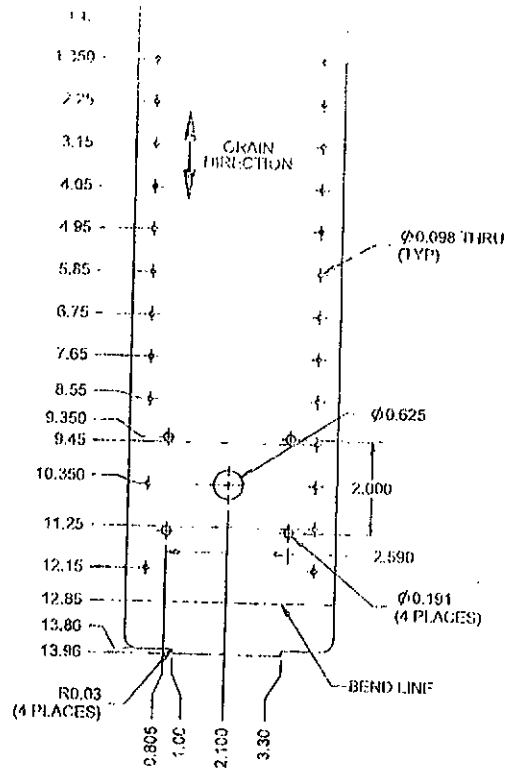
**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050))
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-1/2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.14 lbs.

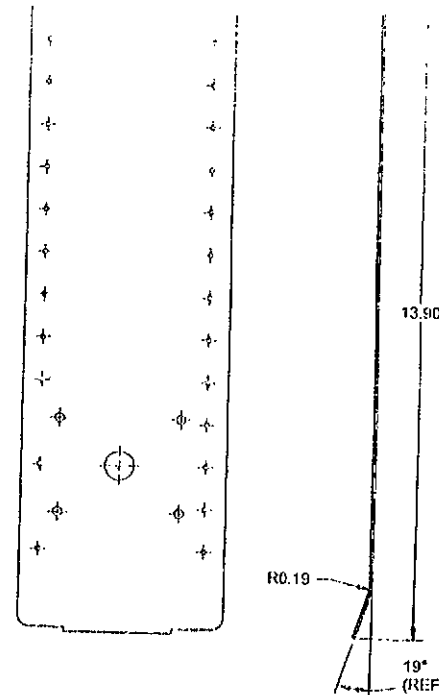
100748 M  
130505

A		NEW ISSUE, REPLACES G10604		LE	07.07.27
REV.		DESCRIPTION		BY	DATE
DESIGN	IS	DART AEROSPACE USA, INC.		REV. A	
DRAWN	LE	PORT HADLOCK, WA		SHEET 1 OF 2	
CHECKED	BE	DRAWING NO.	D3639	SCALE:	
MFG. APPR.	BE	TITLE	DOUBLER	2.3	
APPROVED	BE	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.			
DATE	07.07.27	ALL RIGHTS RESERVED. NO PART OF THIS DOCUMENT MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.			





**D3639-3F FLAT PATTERN  
(D3639-4F OPPOSITE)**



**D3639-3 DOUBLER  
(WAS GENEVA P/N G10604-4)  
D3639-4 OPPOSITE  
(WAS GENEVA P/N G10604-5)**

**RELEASED**  
07.07.27

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-3/4" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.3 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	CE	FORT HADLOCK, WA	
CHECKED	CE	DRAWING NO.	REV. A
MFG. APPR.	CE	D3639	SHEET 2 OF 2
APPROVED	CE	TITLE	SCALE
DATE	07.07.27	DOUBLER	75

